January 22, 2010 3:03:07 PM

Page 1

Item ID:

D119-696-013

Accept

Setup Start

Stop



Revision ID:

Item Name:

Dual Cargo Mirror Installation / [,

Start Date:

Required Date: 2/11/10

Start Qty: Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Date: 10-1-22 Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Plan

Code

Stop

Sequence ID/ **Work Center ID** **Operation** Description Set Up/ **Run Hours** Draw Number Draw Rev.

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Draw Nbr

N/A

100

Rev U/R

Revision Nbr

0.00

Document Control

Memo

DOCUMENT CONTROL

0.00 Photocopy bluefile & type labels per PPP D119-696-013

110

Packaging

Packaging

0.00

Memo

QC4-100% Inspect kits for completeness

0.00

Packaging

120

QC

Quality Control

Memo

>) Sidulos

0.00

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						1			
Part No	-	PAR #:	Fault Cate	egory:	NCR: Yes	No DO	Δ.	Date:	
		solution:							
NCR:				ER NON-CONFORMA					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sign Date	& Sect	cation ion C	Approval Chief Eng	Approval QC Inspector
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January 22, 2010 3:03:07 PM

Page 2

Item ID:

D119-696-013

Accept

Date:

Draw

Rev.

Plan

Code

Setup Start

Stop



Revision ID:

Start Date:

Dual Cargo Mirror Installation Item Name:

Required Date: 2/11/10

Start Qty: 2.00 1/22/10

Req'd Qty: 2.00

Operation

Description

Packaging

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Tooling: Date:

Date:

Draw

Number

Run

Start

Reject

Number



Insp.

Sequence ID/ **Work Center ID**

130

Packaging Packaging

Memo

Identify and pack for shipping as per PPP_D119-696-013

Date: _____

Location: PPP Rev:

QC21- Final Inspection - Work Order Release

0.00

SPC (Y/N):

Set Up/

0.00

0.00

Run Hours

Quality Control

140

Memo

0.00

Reject

Qty

Stop



10-2-3

Accept

Qty

10/02/03 95/ Mr 10-2-3

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	•											
W/O:			WO	ORK ORDER CHANG	ES							
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
					·				}			
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:							
		solution:	Dispositio	n:	QA: N/C	Closed: _		Date: _				
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NO	R)						
DATE	STEP	Description of NC		ion B	Verif	ication	Approval	Approval				
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Dat	& Sec	tion C	Chief Eng	QC Inspector			
						!			}			
		•										
				<u> </u>								
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Picklist Print January 22, 2010 3:03:11 PM Work Order ID: 55599 D119-696-013 Parent Item: Parent Item Name: **Dual Cargo Mirror Installation Start Date: 1/22/10** Required Date: 2/11/10 Comments: IPP Rev:A□08-02-19□New issue □DD verified by: LL Start Qty: 2.00 Required Qty: 2.00 Component Item ID/ Replacement Mfg/ Bin Primary Last Route Unit of Qty on Remaining Qty Date Status Item Name Item ID Item Location Location Seq ID Measure Hand Qty To Pick Issued Purch Issued ALS4-1032-130 20 Purchased No 2,553.000 4.0000 Each Warehouse Loc Qty Loc Code Location Main Warehouse 2553 11051 2553 AN526-1032R9 4 9 Purchased No Each 55.0000 8.0000 Warehouse Loc Qty Loc Code **Location** Main Warehouse ST 55 101189 6 11AS/14900363 N QSI OIT S 110584 5 111758 AN960JD10 4φ Purchased No 0.0000 8.0000 Each



Washer

D119-696-043

Manufactured

No

0.0000 Each

M113368 10-2-25/ B 3560 / (4)

Dual Cargo Mirror Assy

W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	A:						
Res		solution:	Dispositio	n:	QA:	N/C Clo	sed:		Date:	
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR)			
DATE	STEP	Description of NC						cation		Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect	ion C	Chief Eng	QC Inspector
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January 22, 2010 3:03:11 PM

Work Order ID: 55599

Parent Item:

D119-696-013

Parent Item Name:

Dual Cargo Mirror Installation

Comments:

IPP Rev:A□08-02-19□New issue □DD verified by: LL



Start Date: 1/22/10

Required Date: 2/11/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
D2053		Manufactured	No				Each	23.0000	2.0000	86.4-0	J	



Warehouse

Loc Code Loc Oty

Location Main Warehouse 23 38531 22 47595 Each 36.0000 2.0000



Manufactured No

Warehouse	Loc Oty	Loc Code	
Location			
Main Warehouse	•		
ST006	1		
39558	1		
Main Warehouse			
ST <u>6</u>	35		
54698	35		

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W/O:		And the state of t	WO	RK ORDER CHANGI	ES						
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQA:	Date: _				
	Re	esolution:	Disposition	l:	QA: N/C Clo	sed: Date:					
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)					
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval			
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
								:			
	1					1		<u> </u>			

Picklist Print

Page 3

January 22, 2010 3:03:12 PM

Work Order ID: 55599

Parent Item:

D119-696-013



Parent Item Name: Dual Cargo Mirror Installation

Start Date: 1/22/10

Required Date: 2/11/10

Comments:	IPP Rev:A[]08-02-	19□New issue □	DD v	erified by: LL				;	Start Qty: 2.00	R	equired Qty:	2.00
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2071 Cable Assembly		Manufactured	No				Each	11.0000	2.0000	0-2-2	5/	7
				Wareho Loca Main Wa ST	<u>ition</u>	<u>Loc (</u>	<u>Qtv</u> 11	Loc Code				
D3083-1 (Y		Manufactured	No		47601 54777		1 10 Each	14.0000	2.0000	1 3 10-2-2	S _I	0
(1.1				Wareho Loca Main Wa	<u>rtion</u>	Loc	<u>Qty</u>	Loc Code			•	
MS21919-DG5 2 >	E 1911 NOBER BY MIN BOOK BIN 1881	Purchased	No	ST (47605 47686		14 4 10 Each	49.0000	4.0000	7	c	1
Clamp	1			<u>Wareho</u> <u>Loca</u>		<u>Loc</u>	<u>Qty</u>	Loc Code	- <i></i>	10-2-3		
				Main Wa ST	110916		49 49		-	8		

W/O:			WO	RK ORDER CHANG	BES					
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							1			
Res		PAR #:	Fault Categ	jory:	NCR: Yes No DQA:					
		solution:	Disposition	ı:	QA: N/C C	osed:		Date: _		
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCF	R)				
DATE	STEP Description of NC				Section B Vo			Approval	Approval	
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC Inspector	
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Picklist Print

January 22, 2010 3:03:12 PM

Work Order ID: 55599

Parent Item:

D119-696-013

Parent Item Name:

Dual Cargo Mirror Installation

Comments:

IPP Rev:A□08-02-19□New issue □DD verified by: LL

Purchased

No



Start Date: 1/22/10

Required Date: 2/11/10

Page 4

Start Qty: 2:00

Required Qty: 2.00

	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
	MS27039-1-09 μ φ		Purchased	No				Each	761.0000	8.0000/6			v
. 1			1								ハンコ	50	

Warehouse Loc Oty Loc Code Location Main Warehouse ST 761 23 500 205 8912 33 108.0000 2.0000 9 Each



Warehouse Loc Qty Loc Code Location Main Warehouse ST 108 107376 28 109371 80

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W/O:		WORK ORDER CHANGES											
DATE	STEP	PR	IGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
Part No:		PAR #:	Fault Categ	jory:	NCR: Yes	No DQA:	Date: _						
	Re	esolution:	Disposition: QA: N/C Closed: Dat					•					
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)							
DATE	STEP	Description of NC	Corrective Action Section B			Verification		Approval					
	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector					
1													

					Ì								



25.2 **CARGO MIRROR REMOVAL**

- Loosen MS21042-3 nut and remove D2071 control cable from D2067 connector. 1.
- Remove (4) MS27039-1-09 screws and remove D3072-1/-2 brackets. Re-install MS27039-1-08 2.
- 3. Remove (2) AN526-1032R9 screws and (2) MS21919DG5 clamps.
- Remove (2) AN526-1032R9 screws, the D2053 bracket and the D2071 cable assembly. Reinstall AN526-1032R9 screws to plug inserts.
- 5. Seal MS35489-9 grommet hole with PRC / RTV / Proseal 890 / Sikaflex-241 / Sikaflex-291 / MIL-C-8802 Class B2 sealant.

25.3 **WEIGHT AND BALANCE**

		Weight	LATERAL		LONGITUDINAL		
Installation O	: 4		Arm	Moment	Arm	Moment	
D119-696-011		2.2 lb	7.0 in	15.4 in-lb	22.0 in	48.4 in-lb	
Cargo Mirror Installation		1.00 kg	0.28 m	0.28 m-kg	0.87 m	0.87 m-kg	
D119-696-013		3.0 lb	1.0 in	3.0 in-lb	22.0 in	66.0 in-lb	
Cargo Mirror Installation		1.36 kg	0.04 m	0.05 m-kg	0.87 m	1.18 m-kg	

25 / **PARTS LIST**

25.4	PARTS	LIST			
Qty -011	/ Qty / 013	Qty -041	Qty -043	Part Number	Description
Х				D119-696-011	SINGLE CARGO MIRROR INSTALLATION
	Х			D119-696-013	DUAL CARGO MIRROR INSTALLATION
1		Х		D119-696-041	SINGLE CARGO MIRROR ASSEMBLY
	1		Х	D119-696-043	DUAL CARGO MIRROR ASSEMBLY
		1	2	D2011-101	MIRROR ASSEMBLY
1	1			D2053	BRACKET
		2	2	D2054	BUSHING
		2	2	D2055	CLAMP
		1	1	D2056	BELL CRANK
-		1		D2057	PLUG
1	71			D2067	CONNECTOR
1	/ 1.			D2071	CABLE ASSEMBLY
		1	2	*D3014-1	LOCKNUT
.,		1	1	D3072-1	BRACKET
	:-	1	1	D3072-2	BRACKET
.17		1		D3074-1	ARM
			1	D3074-3	ARM
1	1			D3083-1	PLACARD
4	4			AN526-1032R9	SCREW
4	7 4	6	6	AN960JD10	WASHER
		1	2	*AN960JD416L	WASHER
		3	3	MS21042L3	NUT (or MS21042-3)
2	2			MS21919DG5	CLAMP
4	4			MS27039-1-09	SCREW
		3	3	MS27039-1-18	SCREW
1	1			MS35489-9	GROMMET
2	2			AKS7-1032-130	INSERT (or ALS7-1032-130 or AKS4-1032-130 or ALS7-1032-130 or AELS-032-130)

*INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY

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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHAP	DURE CHANGE B			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Categ	jory:	_ NCR: Yes	No DQ	A:	Date:	
			Disposition	_ QA: N/C CI	QA: N/C Closed: Date:				
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	TEP Description of NC Section A	Corrective Action Initial Action Descrip Chief Eng Chief Eng		Section B otion Sign & Date		cation ion C	Approval Chief Eng	Approval QC Inspector
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4 g	t								